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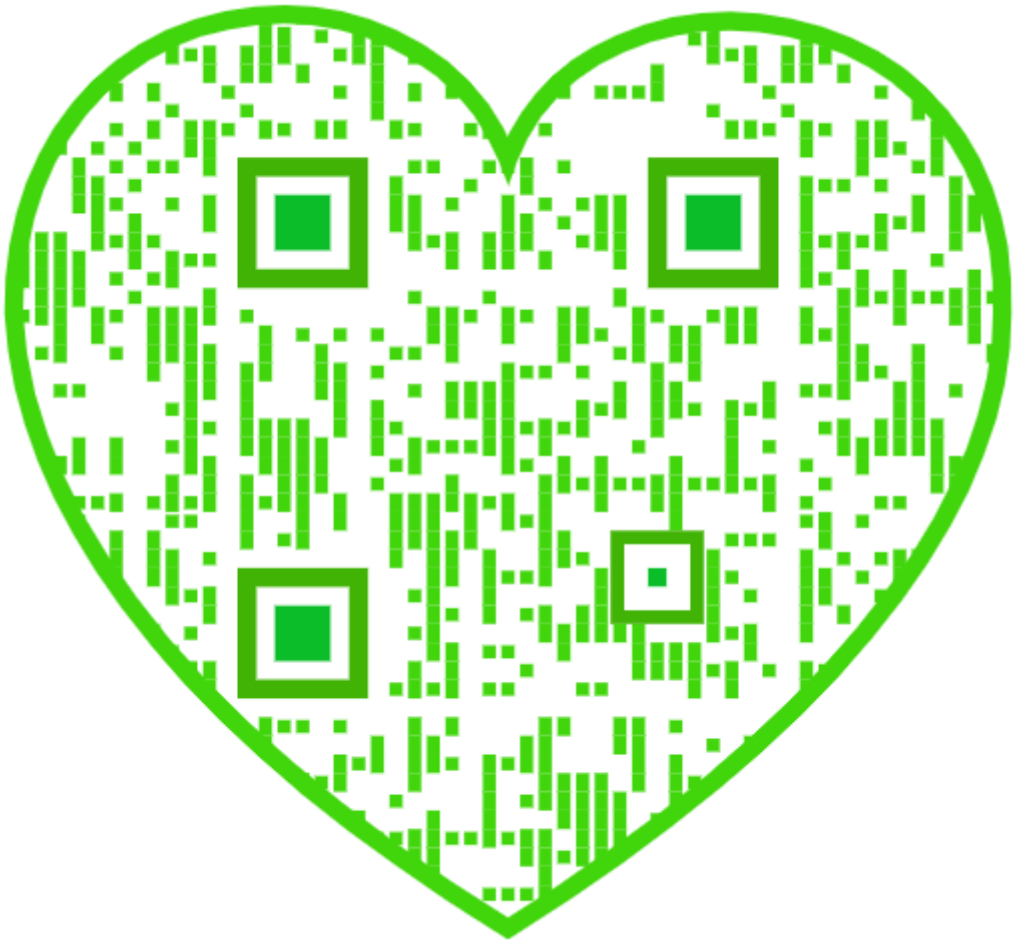
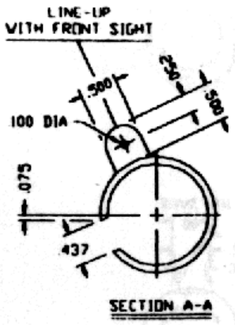
1- scale print of OWEN MK II 1943

1- scale print of REISING

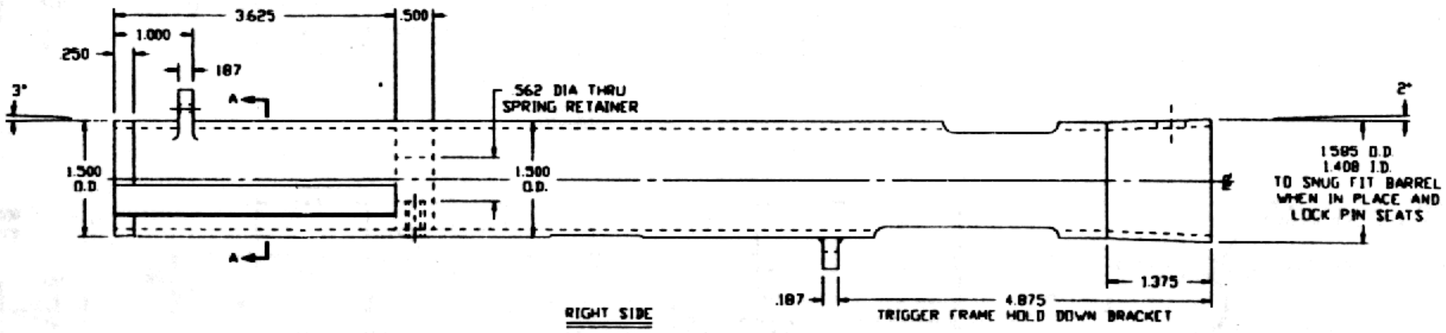
1- scale print of SPRINGFIELD M-60 lt. MG

PARTS SUPPLIERS ON LAST PAGE

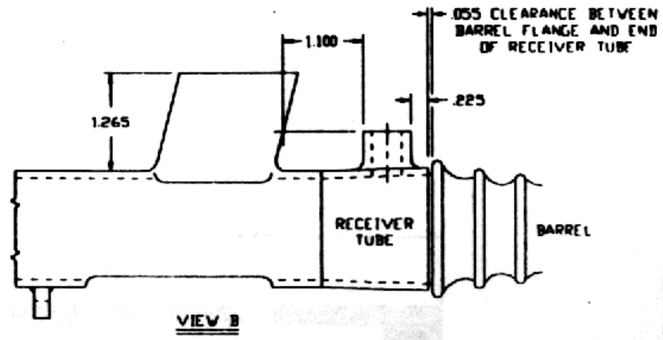




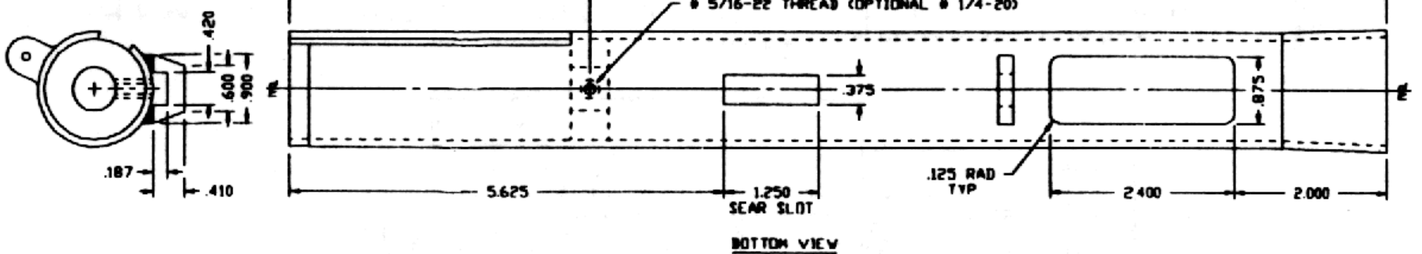
SECTION A-A



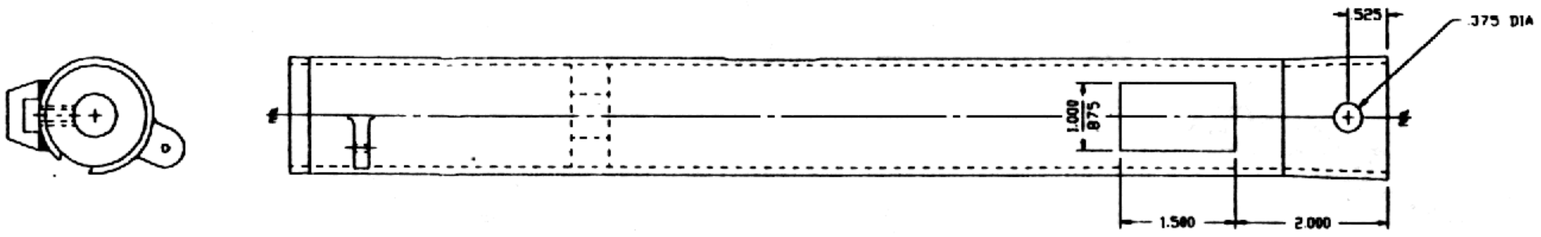
RIGHT SIDE



VIEW B



BOTTOM VIEW



TOP VIEW

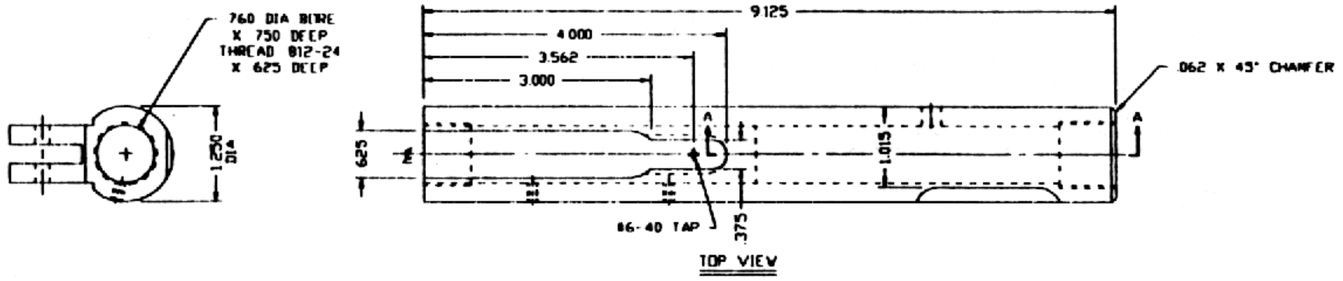
NOTES

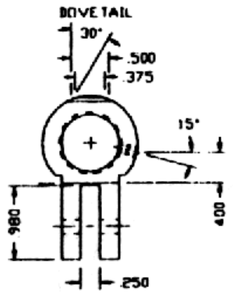
1. MATERIAL- 1625 O.D. X 1.312 I.D. D.O.M. STEEL TUBE
2. FINISH- PAKERIZE THEN PAINT BLACK OR CAMOFLAGE
3. SOME PART KITS COME WITH FRONT RECEIVER PARTS IN TACT. IF THIS IS YOUR CASE, THEN REAR PART OF RECEIVER TUBE CAN BE ALIGNED AND BUTT WELDED.
4. IF PARTS ARE LOOSE, REFER TO "VIEW B" FOR THEIR LOCATION
5. Ø 5/16-22 THREAD IS BRITISH AND CAN BE SUBSTITUTED WITH #7 DRILL (.201 DIA) AND TAP Ø 1/4-20 THREAD. REPLACE ORIGINAL Ø 5/16 SCREW WITH Ø 1/4-20 ROUND HEAD SCREW
6. SPRING RETAINER IS 1.312 O.D. WITH .562 DIA HOLE IN CENTER AND .500 WIDE. WELD IN PLACE USING 3 OR 4 DRILLED HOLES EQUALLY SPACED IN RECEIVER TUBE AT 3.875 DIMENSION AFTER ARC WELDING SPRING RETAINER AND RECEIVER TUBE TOGETHER DRILL AND TAP Ø 1/4-20 HOLE IN BOTTOM FOR TRIGGER FRAME HOLD DOWN SCREW.
7. WHEN 3° TAPER IS CUT ON REAR OF RECEIVER TUBE IT SHOULD MEASURE 1.480 AT SMALL END. DUST COVER FITS IN PLACE OVER THIS TAPER.
8. EARLY MODEL BARRELS WERE FINNED. LATE MODEL BARRELS WERE PLAIN.

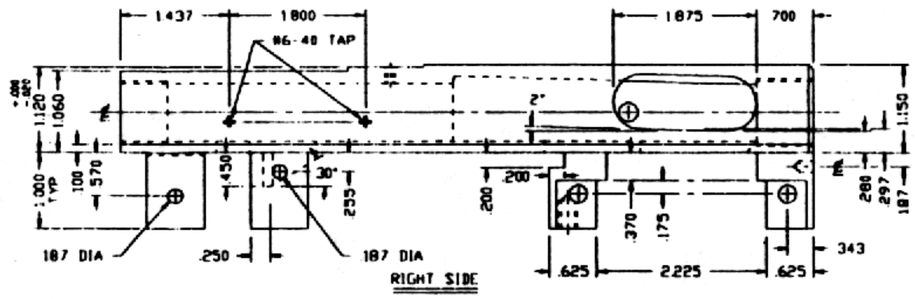
RESTRICTED
MATERIAL

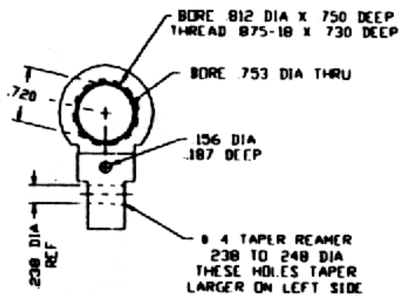
CONFIDENTIAL

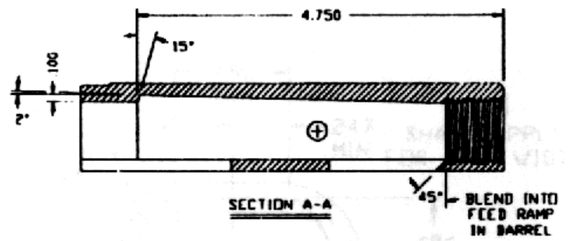
SCALE FULL	MATERIAL SEE NOTE 1	CKD.	TOLERANCES
DWN	FINISH SEE NOTE 2	DATE	
TITLE: OWEN MK II MODEL 1943 RECEIVER		REV.	ANGLES ± 8°
			NO.

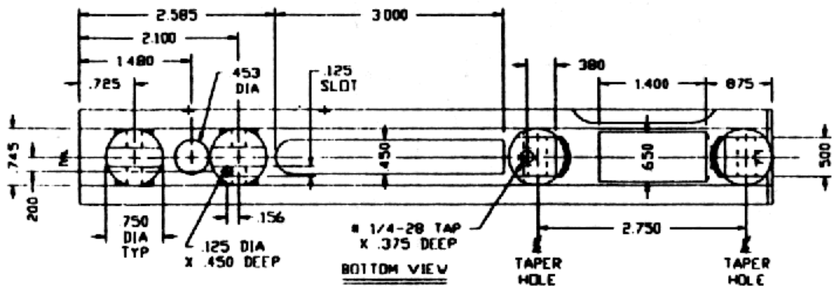


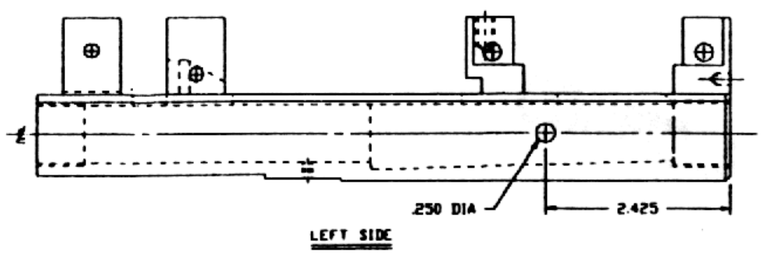


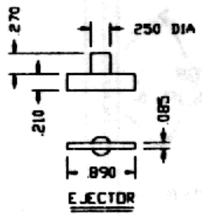










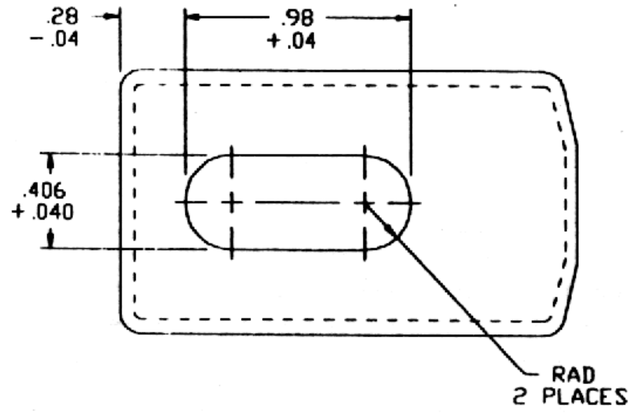


CONFIDENTIAL

NOTES:
1. MATERIAL - 1020 STEEL D.O.M. TUBING
2. FINISH- MILITARY 50 PARKERIZE, CIVILIAN 50 OR 60 BLUE
3. DARKENED AREAS AROUND .750 DIA POST REPRESENT ELECTRIC WELDS AFTER POSTS HAVE BEEN BRAZED OR SILVER BRAZED IN PLACE JUST LIKE ORIGINAL RECEIVER
4. .375 AREA OF SIGHT SLOT IS UNDERCUT WITH A 60° DOVETAIL CUTTER
5. EJECTION PORT IS ANGLED TO RESULT IN .280 DIMENSION IN FRONT AND .297 IN REAR
6. BORE OR REAM .753 DIA THRU HOLE BEFORE CUTTING OFFSET
7. SEMI AUTOMATIC RECEIVER CAN BE ACCOMPLISHED BY NOT CUTTING .125 SLOT WITH 30° RAMP AND .125 HOLE X .450 DEEP THIS WILL NOT ALLOW DISCONNECTOR TO BE ASSEMBLED

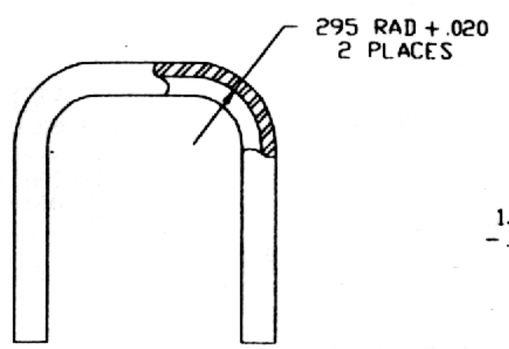
RESTRICTED
MATERIAL

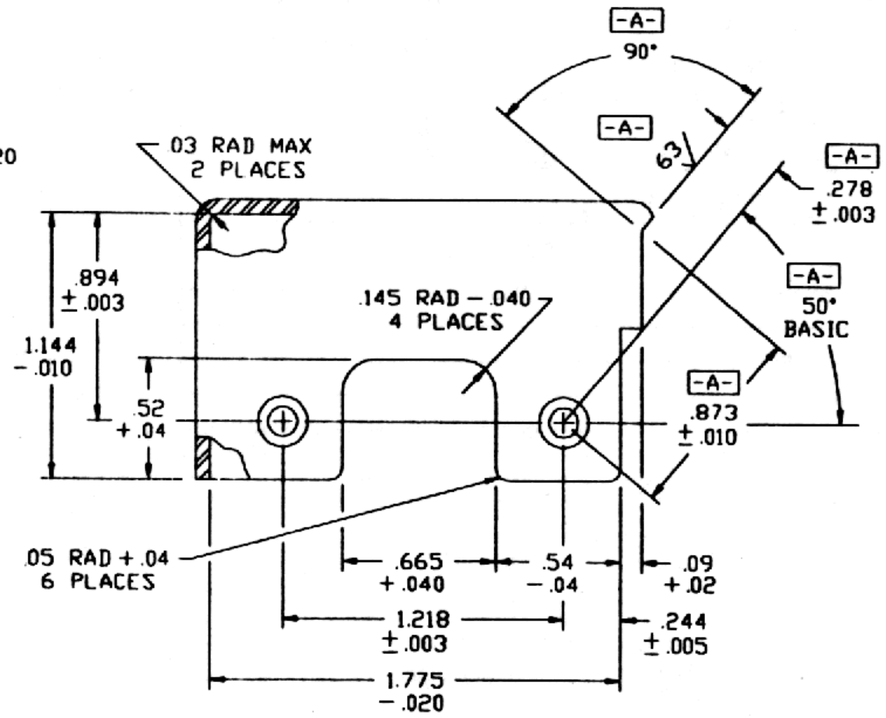
SCALE: FULL	MATERIAL: SEE NOTE 1	CKD	TOLERANCES
DWN	FINISH: SEE NOTE 2	DATE	
TITLE: REISING RECEIVER		REV.	NO

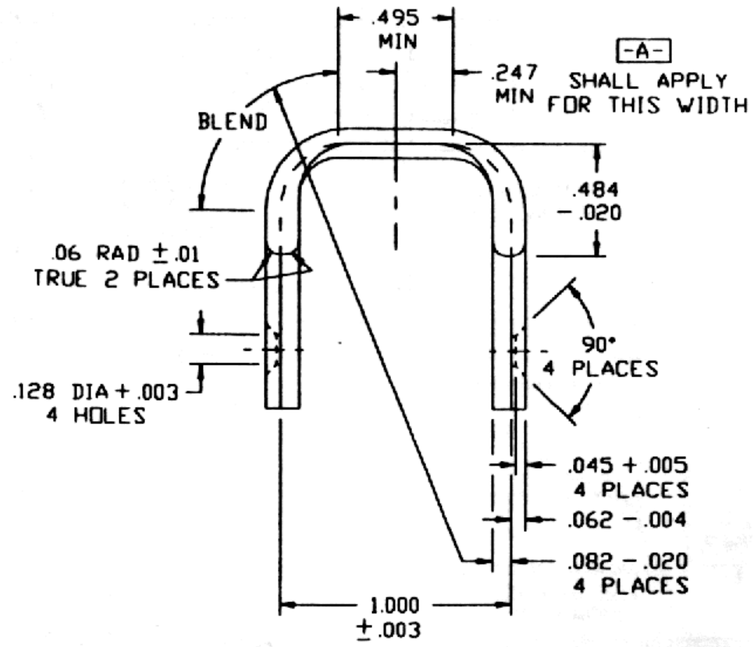


NOTES:

1. FINISH 125 EXCEPT AS NOTED. SHEARED SURFACES 250.
2. ALL EDGES SHALL BE BROKEN 005 +.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL- STEEL QQ-S-698 CARBON .17 TO .24, MANGANESE .30 TO .60 DRAWING QUALITY KILLED.
4. HEAT TREATMENT- CARBURIZE AT 1600°F FOR .005 TO .010 CASE DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENT ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBONITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. FILEHARD TEST IN ACCORDANCE WITH SA-STD-104. (H1)
6. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171







RESTRICTED
MATERIAL

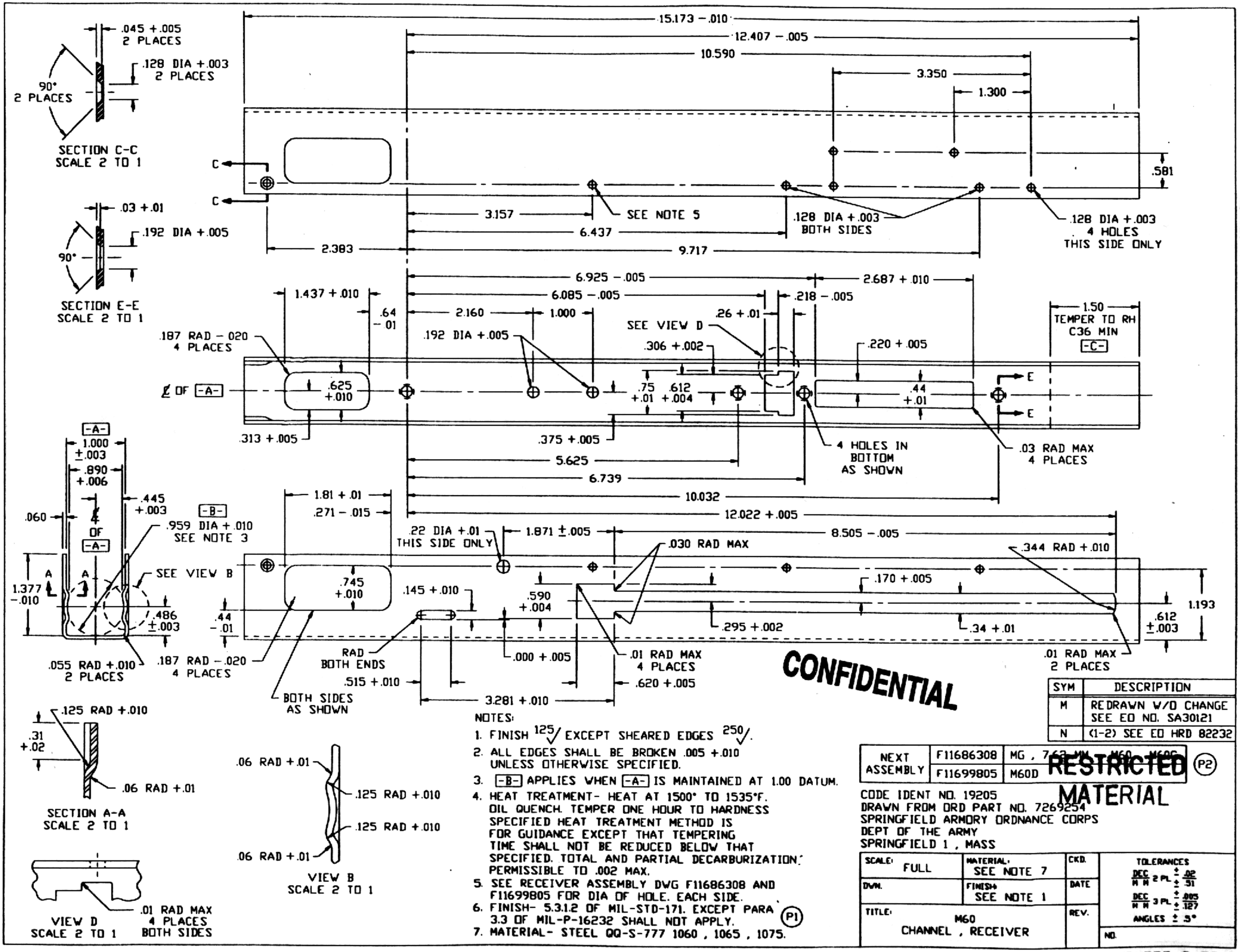
CONFIDENTIAL

NEXT ASSEMBLY	F11686308	MG , 7.62 MM - M60 , M60C.
	F11699805	M60D

CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269252
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1 , MASS

SYM	DESCRIPTION
G	REDRAWN WITH CHANGE SEE EO NO. SA30116
H	(1) SEE EO HRD 82232

SCALE: 2 TO 1	MATERIAL: SEE NOTE 3	CKD.	TOLERANCES DEC M M 2 PL ± .02 ± .51
DWN.	FINISH: SEE NOTE 1	DATE	DEC M M 3 PL ± .005 ± .127
TITLE: M60 BRIDGE , RECEIVER		REV.	ANGLES ± .5°
			NO.



CONFIDENTIAL

SYM	DESCRIPTION
M	REDRAWN W/O CHANGE SEE EO NO. SA30121
N	(1-2) SEE EO HRD 82232

NOTES:

1. FINISH 125/ EXCEPT SHEARED EDGES 250/.
2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. -B- APPLIES WHEN -A- IS MAINTAINED AT 1.00 DATUM.
4. HEAT TREATMENT- HEAT AT 1500° TO 1535°F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. TOTAL AND PARTIAL DECARBURIZATION PERMISSIBLE TO .002 MAX.
5. SEE RECEIVER ASSEMBLY DWG F11686308 AND F11699805 FOR DIA OF HOLE. EACH SIDE.
6. FINISH- 5.3.1.2 OF MIL-STD-171. EXCEPT PARA 3.3 OF MIL-P-16232 SHALL NOT APPLY. (P1)
7. MATERIAL- STEEL QQ-S-777 1060 , 1065 , 1075.

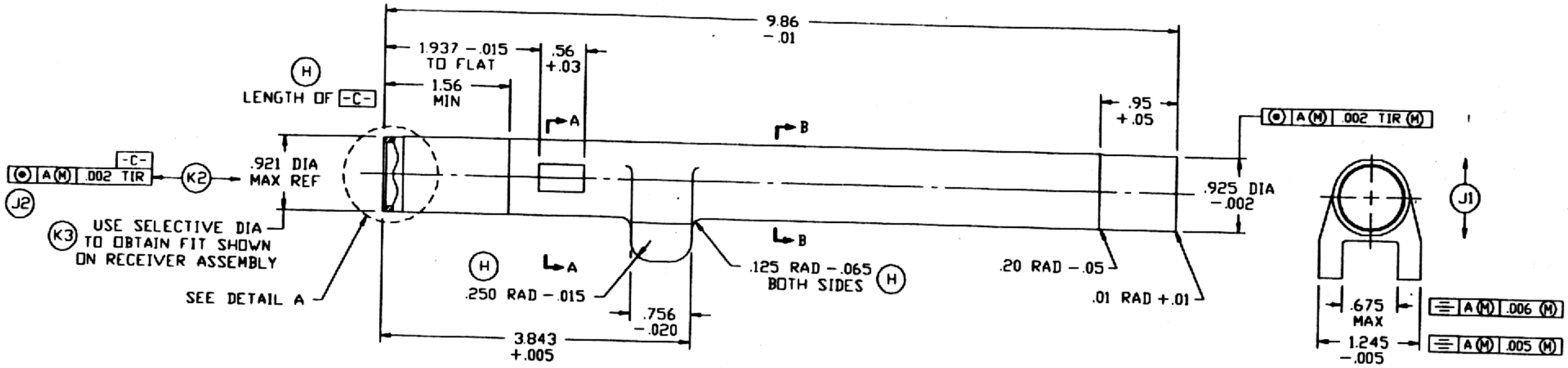
NEXT ASSEMBLY	F11686308	MG , 7.62 MM M60 M60C
	F11699805	M60D

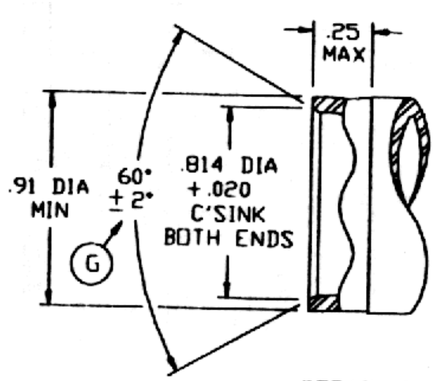
RESTRICTED (P2)

MATERIAL

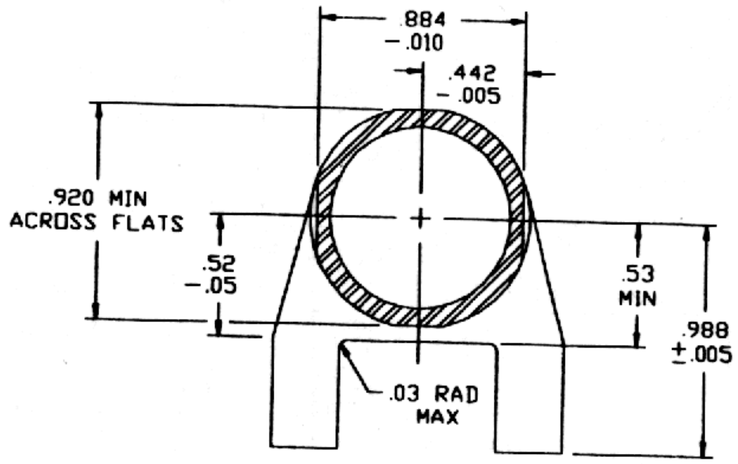
CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269254
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1 , MASS

SCALE: FULL	MATERIAL: SEE NOTE 7	CKD.	TOLERANCES
DWN.	FINISH SEE NOTE 1	DATE	DEC 2 PL ± .02 / ± .51
TITLE: M60 CHANNEL , RECEIVER		REV.	DEC 3 PL ± .005 / ± .127
			ANGLES ± .5°
			NO.

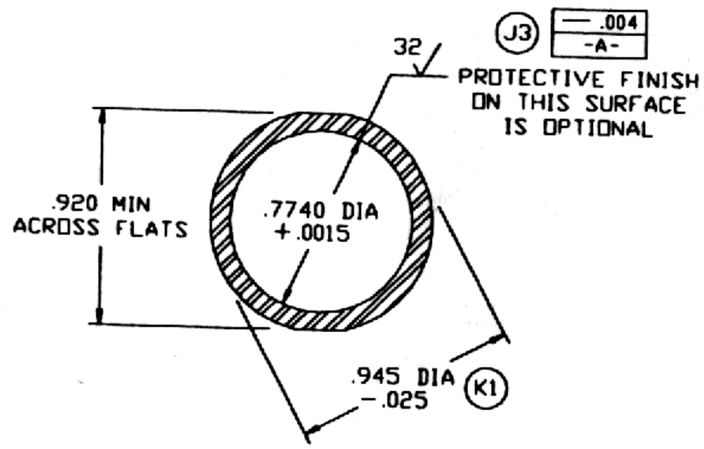




DETAIL A
SCALE 2 TO 1



SECTION A-A
SCALE 2 TO 1



SECTION B-B
SCALE 2 TO 1

NOTES:

1. FINISH 125 EXCEPT AS NOTED. FORGED SURFACES 250.
2. MATERIAL- STEEL, COMP 4140, SPEC QQ-S-624 (J5) OR COMP 1141, SPEC QQ-S-637, EXCEPT HOT FINISHED 1141 STEEL BARS FOR FORGING PURPOSES, AND ALL OTHER CONDITIONS OF SPECIFICATIONS ARE (L1) COMPLIED WITH.
3. HEAT TREATMENT- HEAT AT 1525° TO 1575°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

CONFIDENTIAL

RESTRICTED MATERIAL

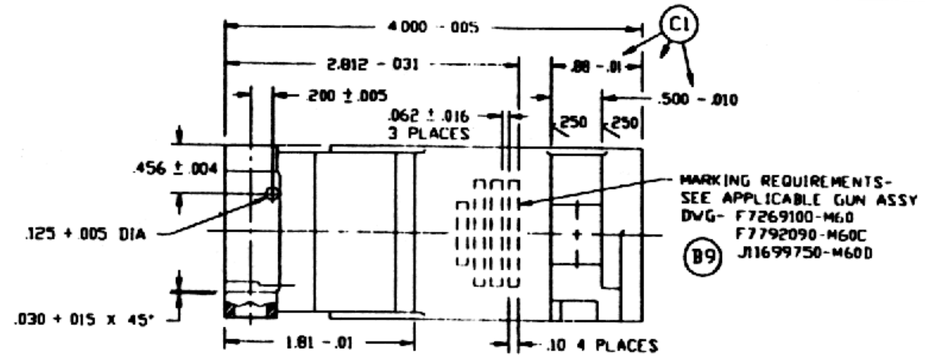
SYM	DESCRIPTION
E	←
F	REDRAWN & REVISED SEE EO SA26085
G2	REF EO NO. SA27115
H5	REF EO NO. SA27297
J	(1-5) REF EO SA28042
K	(1-3) SEE EO SA29002
L	(1) SEE EO HRD 82370

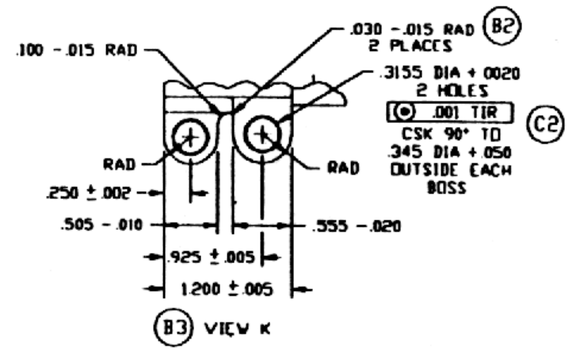
J4 G

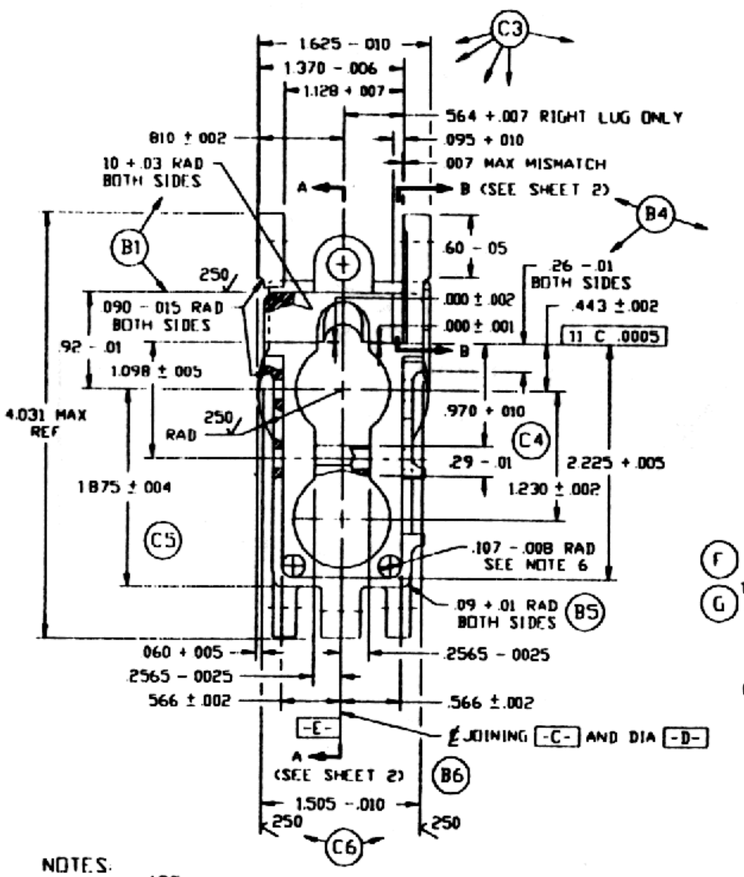
NEXT ASSEMBLY	F11686308	MG , 7.62 MM - M60 , M60C.
	F11699805	M60C

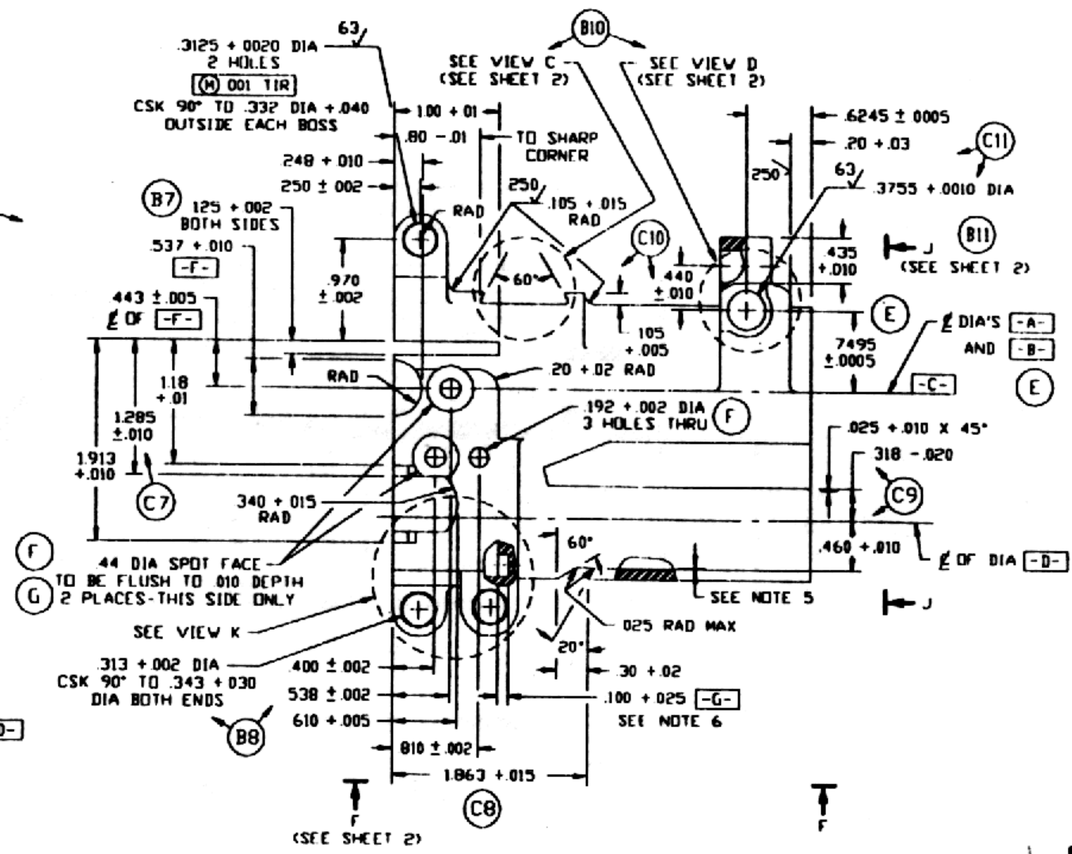
CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269256 (H)
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1 , MASS

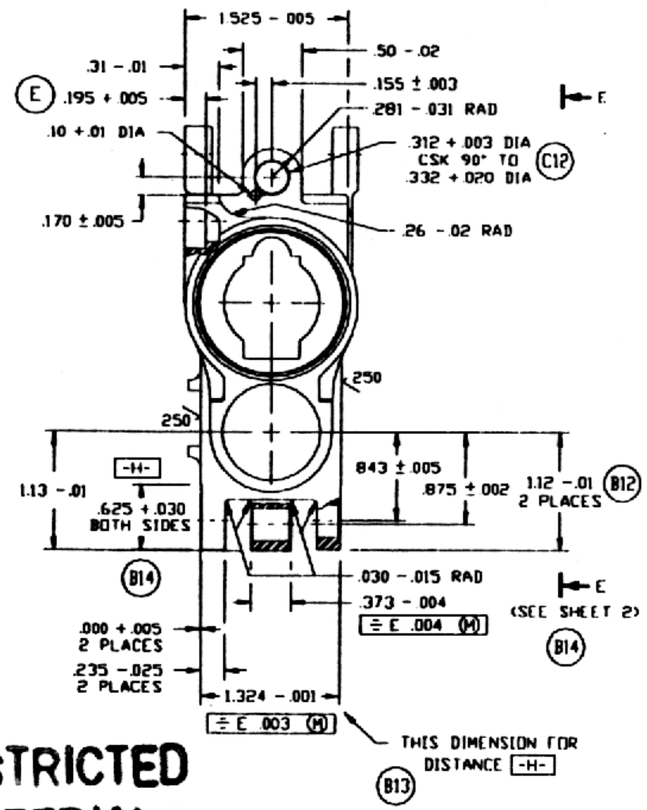
SCALE: FULL	MATERIAL: SEE NOTE 2	CKD.	TOLERANCES DEC M M 2 PL ± .02 ± .51; DEC M M 3 PL ± .005 ± .127; ANGLES ± .5°
DWN.	FINISH: SEE NOTE 1	DATE	
TITLE: M60 GUIDE , OPERATING ROD		REV.	NO.











NOTES:

1. FINISH 125 EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. ALL UNSPECIFIED RADII SHALL BE .030 +.030.
4. HEAT TREATMENT- HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. BREAK THRU SHALL BE PERMISSIBLE IN THIS AREA PROVIDED RESULTANT BURRS ARE REMOVED.
6. .215 DIA -.015 (2) HOLES MAY BE MACHINED IN CORNERS FOR DEPTH -G- TO PROVIDE REQUIRED RADIUS.
7. FINISH 5.3.1.2 OF MIL-STD-171. (G)
8. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED (D) OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL.
9. MIL-W-13855 APPLIES. (E)
10. MATERIAL- STEEL QQ-S-624 4140 , 8640 , 8740.

CONFIDENTIAL

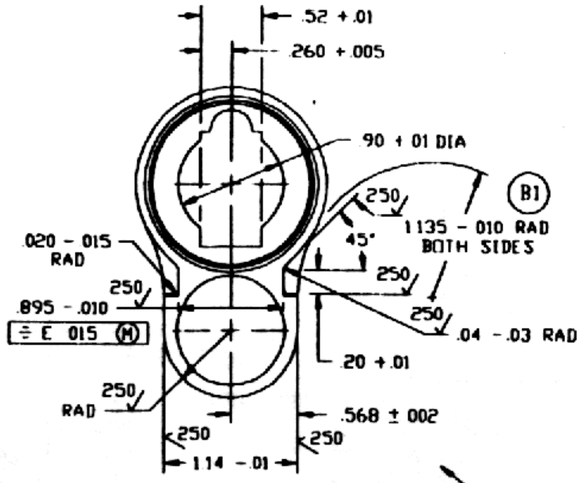
RESTRICTED
MATERIAL

SYM	DESCRIPTION
A	SEE ED SA29002
B	(1-14) SEE ED SA30032
C	(1-15) SEE ED 82128
D	(1-2) SEE ED HRD 82232
E	(1-4) SEE ERR HDR 10724
F	(2) SEE ERR HDR 30781
G	(2) SEE HDR 75E0036-0002

NEXT ASSEMBLY	F11686308	MG , 7.62 MM - M60 , M60C
	F11699805	M60D

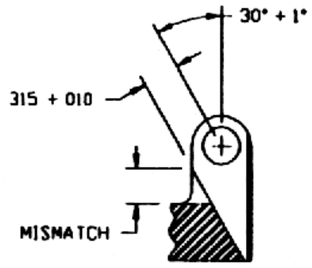
CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 11686307 SHEET 1 OF 2
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND , ILL.

SCALE: FULL	MATERIAL: SEE NOTE 10	CKD.	TOLERANCES DEC 2 PL ± .02 / M M ± .51 DEC 3 PL ± .005 / M M ± .127 ANGLES ± .5°
DWN.	FINISH: SEE NOTE 1	DATE	
TITLE: M60 RECEIVER		REV.	NO.



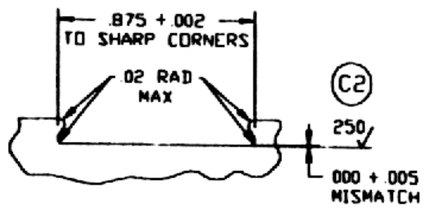
PARTIAL VIEW J-J (SEE SHEET 1) B2

C1

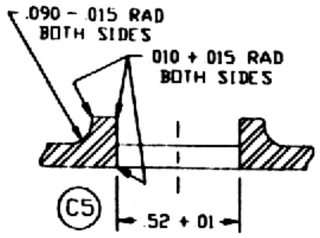


PARTIAL SECTION B-B (SEE SHEET 1)

B3

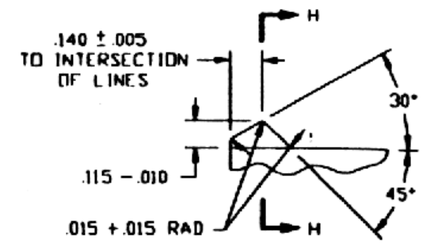


VIEW C SCALE 2 TO 1 (SEE SHEET 1)

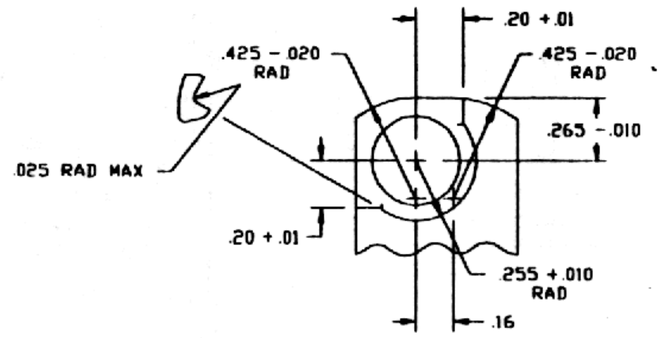


B6 PARTIAL SECTION H-H SCALE 2 TO 1

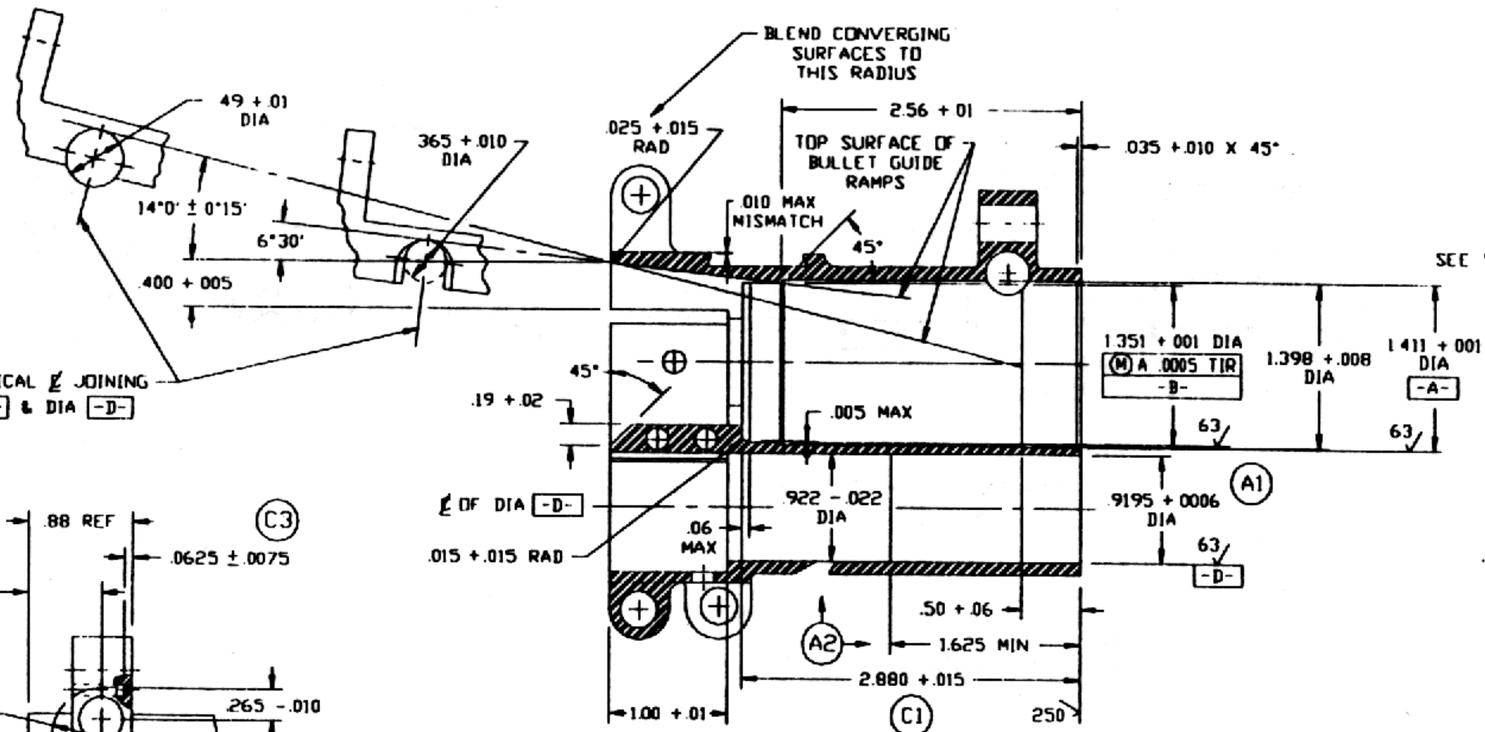
B4



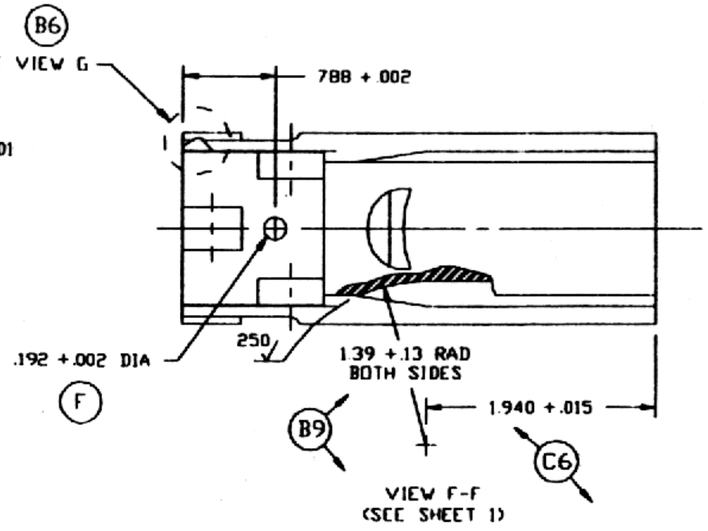
VIEW G SCALE 2 TO 1 B5



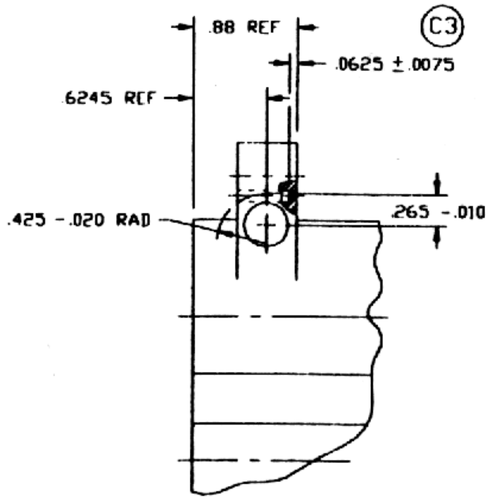
E VIEW D SCALE 2 TO 1 (SEE SHEET 1)



B8 SECTION A-A (SEE SHEET 1)



F VIEW F-F (SEE SHEET 1)



PARTIAL VIEW E-E (SEE SHEET 1) B7

CONFIDENTIAL

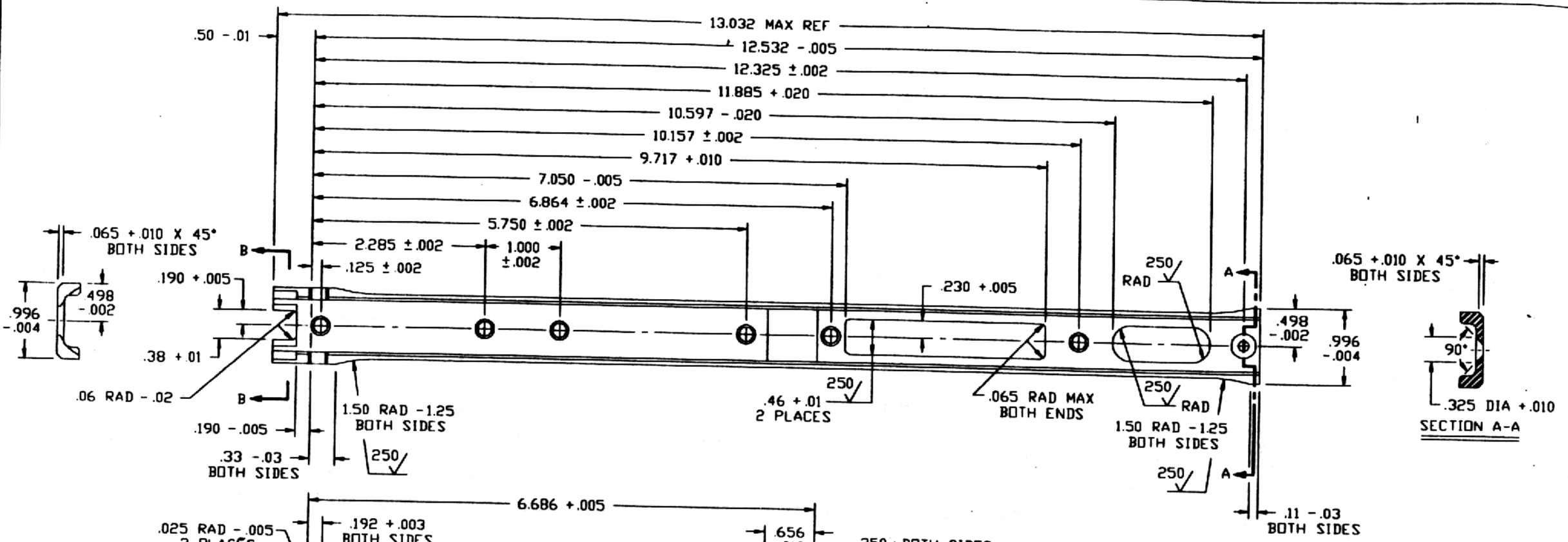
RESTRICTED MATERIAL

NEXT ASSEMBLY	F11686308	MG , 7.62 MM - M60 , M60C.
	F11699805	M60D

CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 11686307 SHEET 2 OF 2
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND , ILL.

SYM	DESCRIPTION
A	(1-2) SEE EO SA29002
B	(1-9) SEE EO SA30032
C	(1-6) SEE EO 82128
D	NO CHANGE
E	(1) SEE ERR HDR 10724
F	SEE ERR HDR 30781
G	NO CHANGE

SCALE: FULL	MATERIAL: SEE SHEET 1	CKD.	TOLERANCES DEC M M 2 PL ± .02 ± .51 DEC M M 3 PL ± .005 ± .127 ANGLES ± .5°
DWN.	FINISH: SEE SHEET 1	DATE	
TITLE: M60 RECEIVER		REV.	NO.



RESTRICTED MATERIAL

CONFIDENTIAL

NOTES:

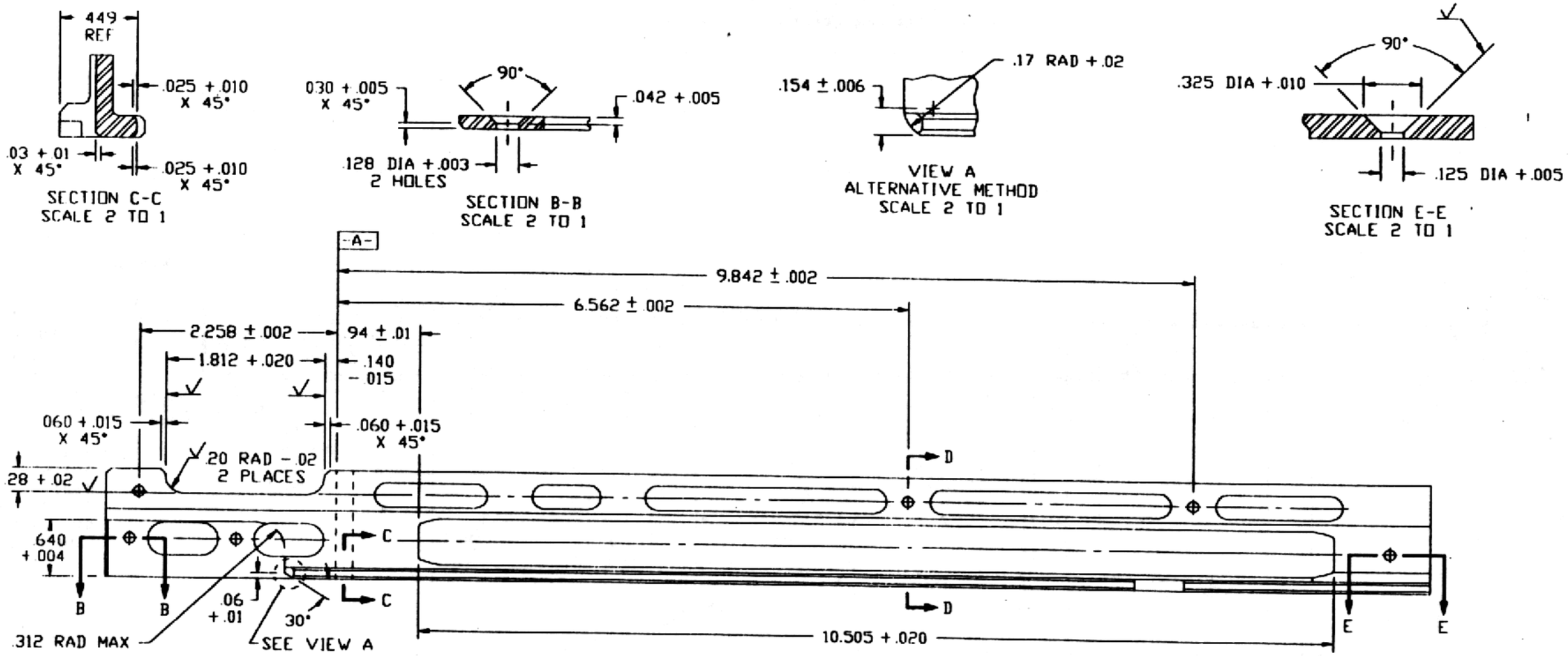
1. FINISH 125 EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT- HEAT AT 1535° TO 1565° F: OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. HEAT TREAT BEFORE MACHINING.
5. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL. (L1)
6. MATERIAL- STEEL QQ-S-624 4140 , 8640 , 8740.

SYM	DESCRIPTION
K	REDRAWN WITH CHANGE SEE EO NO. SA30121
L	(1) SEE EO HRD 82232

NEXT ASSEMBLY		
	F11686308	MG , 7.62 MM - M60 , M60C.
	F11699805	M60D

CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269259
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1 , MASS

SCALE: FULL	MATERIAL: SEE NOTE 6	CKD.	TOLERANCES DEC H H 2 PL ± .02 / ± .51; DEC H H 3 PL ± .005 / ± .127; ANGLES ± .5°
DWN.	FINISH: SEE NOTE 1	DATE	
TITLE: M60 RAIL , RECEIVER , LOWER		REV.	NO.



CONFIDENTIAL

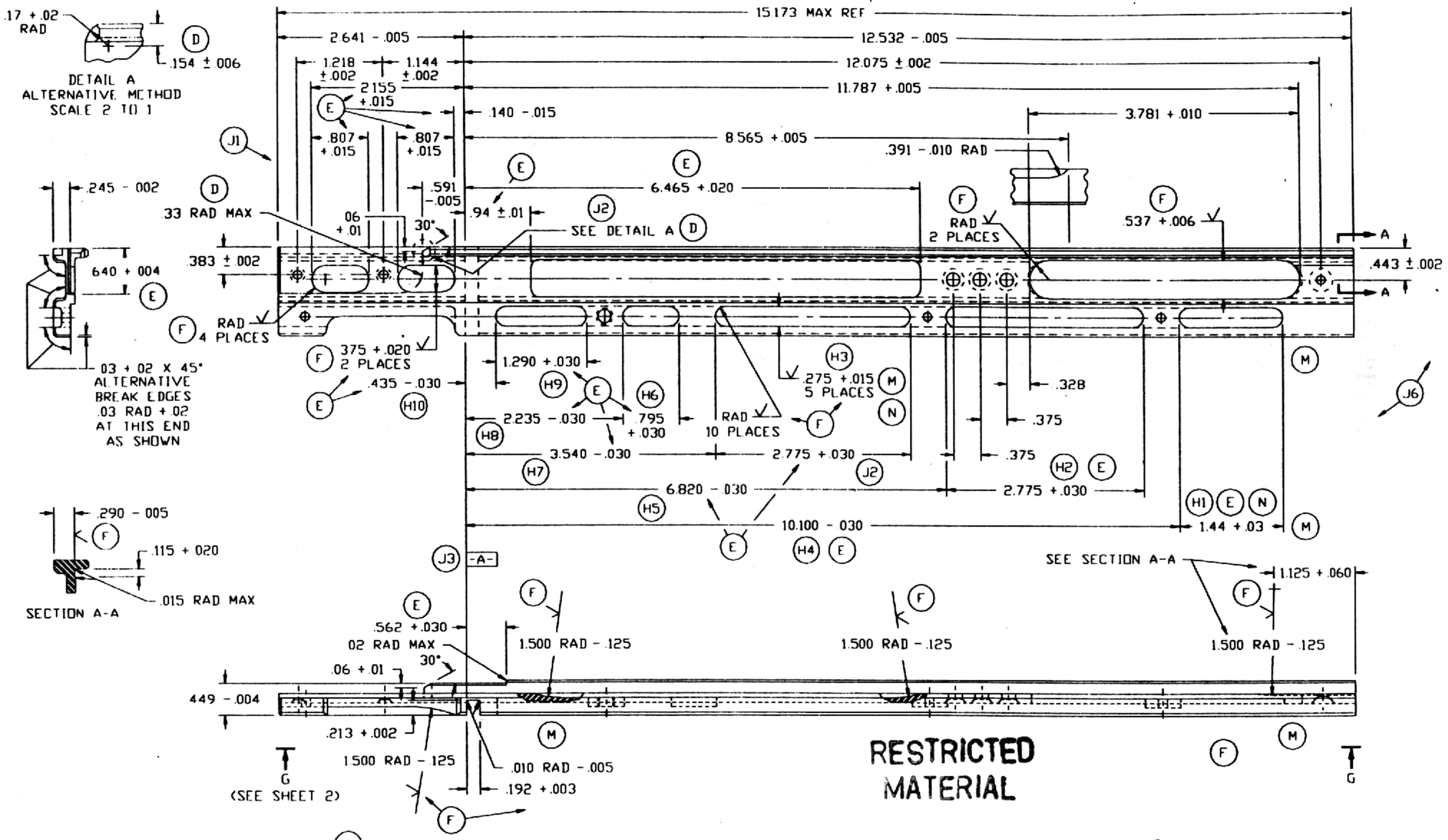
RESTRICTED MATERIAL

SYM	DESCRIPTION
J	REDRAWN WITH CHANGE SEE ED NO. 30122
K	(6) SEE ED HRD 82232
L	(1) SEE ERR HOR 10715
M	SEE ERR HOR 40604

NOTE:
ALL RIVET HOLES AND THEIR COUNTERSINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENTIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL. (K1)

CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 7269258
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND , ILL

SCALE: FULL	MATERIAL: SEE SHEET 1	CKD.	TOLERANCES DEC M M 2 PL ± .02 ± .51; DEC M M 3 PL ± .005 ± .127; ANGLES ± 5°
DWN.	FINISH: SEE SHEET 1	DATE	
TITLE: M60 RAIL, RECEIVER, LEFT HAND		REV.	NO.



RESTRICTED MATERIAL

CONFIDENTIAL

NOTES:

1. FINISH 125 EXCEPT SURFACES MARKED FINISH 250 (F)
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER 1 HOUR TO HARDNESS SPECIFIED. HEAT TREAT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. HEAT TREAT BEFORE MACHINING.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171 (N)
6. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL.
7. MIL-W-13855 APPLIES. (L1) (M)
8. MATERIAL- STEEL QQ-S-624 4140 , 8640 , 8740

SYM	DESCRIPTION
B	←
C	REDRAWN & REVISED SEE EO SA24642
D	REF EO NO. SA24924
E	REF EO NO. SA26992
F	REF EO NO. SA27297
G	(1-2) SEE EO SA28042
H	SEE EO NO SA28992
J	(1-6) EO NO. SA
K	SEE EO NO. SA14466
L	(1-2) SEE EO HRD 82232
M	(1-6) SEE ERR HOR 10715
N	(3) SEE ERR HOR 60604

(G2) (F)

NEXT ASSEMBLY	F11686308	MG , 7.62 MM - M60 , M60C.
	F11699805	M60D

CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 7269260 (G1) (K)
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND , ILL

SCALE: FULL	MATERIAL: SEE NOTE 8	CKD.	TOLERANCES DEC M M 2 PL ± .02 ± .51; DEC M M 3 PL ± .005 ± .127; ANGLES ± .5°
DWN.	FINISH: SEE NOTE 1	DATE	
TITLE: M60 RAIL , RECEIVER , RIGHT HAND		REV.	NO.

LIST OF PARTS SUPPLIERS

wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722

www.gunsnammo.com

international military antiques , inc.
p.o.box 256 millington ,NJ 07946

www.ima-usa.com

inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110

www.inter-ordnance.com

sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980

jeffs shooters supply
p.o.box 1054 trussville , AL 35173

rpb industries
p.o.box 367 avondale est. GA 30002